

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023238**Date Inspected:** 29-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI completed the review of re-flashed welding report submittal 1536R58. The QAI noted that there are general comments regarding the overall status of welding reports that date back to the start of job site construction. Reference the TL-20 report for additional information.

The QAI was requested to sample fastener assemblies that have been delivered to the contractor's job site storage area. The QAI met with Caltrans Transportation Engineer Bob Brignano and was provided with the fastener assemblies' Certificates of Compliance (COCs). The QAI pulled random samples to satisfy the contract requirements for check samples. The QAI assigned lot number B212-009-11 for the LeJeune Bolt Company shipment and B212-010-11 for the Bay Bolt shipment. The QAI also generated TL-102 forms with the pertinent information. See the attached photos.

As reported on 4-28-2011, the contractor was in the process of grinding the full size Electro-Slag Welding (ESW) weld trial (mock up) to incorporate a 6mm planar offset in the top meter, as outlined in the approved request for information (RFI) 2400. The QAI met with the Quality Control Inspector (QCI) Mike Johnson and verified that there are at least 200mm with 6.5mm to 6mm offset at the weld groove. The QAI relayed this information to the QAI Lead Bill Levell and Caltrans Transportation Engineer Doug Wright. There was general agreement that this work conforms to the RFI. The QAI witnessed the contractor's personnel setting up the ESW equipment in order

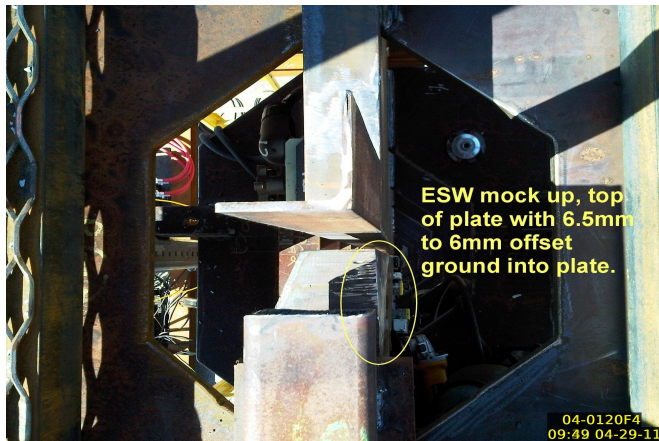
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to run an equipment test on the 1 meter test block. At the end of the shift, the QAI noted that the contractor was experiencing equipment operating difficulties and have not welded out the test block yet. The QAI was informed that the full size mock up will not be welded any earlier than 5-2-2011. See the attached photos.



### Summary of Conversations:

The QAI relayed the status of document reviews, check sampling and ESW mock up status to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Croff, Scott

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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